

WEST**End of Result Set**

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TITLE: DOUBLE ELECTRODE TYPE NARROW GROOVE WELDING

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ABSTRACT:

PURPOSE: To automate weld line copying and to improve its efficiency by positioning a preceding welding torch properly in a narrow groove and making a succeeding welding torch copy by a controlling signal used for position correction of the preceding welding torch.

CONSTITUTION: A TV camera 17 photographs the weld zone of a preceding welding torch 3a, and deviation of the torch 3a in the groove is detected by arc light detecting sensors 9, 9. Information from these is inputted to a controlling device 21 and compared with a reference value, and a correction signal is given to the driving system of the preceding welding torch 3a to make the torch 3a follow up the proper position. The position of the preceding welding torch 3a is stored by a delay copy controlling device 28 and the succeeding welding torch 3b is followed up when welding advanced by the distance between the two torches 3a, 3b. Positional correction for this following-up is made by giving the same signal with that given to the driving system of the preceding torch 3a to the driving system of the succeeding welding torch 3b.

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